

Date: Thursday, 02/04/2009 2:26:11 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET _
Job Number : 46856	
Estimate Number : 11144	
P.O. Number :	Part Number : D32075
This Issue : 02/04/2009 S.O. No. :	Drawing Number : D3207 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 46743	Material :
Written By :	Due Date : 16/04/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.04.02</u>	
Comment : Est A 04.06.09 New issue KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.0773 sf(s)/Unit Total : 0.7728 sf(s)
 6061-T6 .125 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.125" thick
 (M6061T6S.125)
 Identify for D3207-5
 Batch: 110062

ml 09 04 08

(10) (11)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3207
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

ml 09 04 08

(10) (11)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 04 08

(10) (11)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

8090408

(10)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE
 Form as per Dwg D3207

8090408

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:26:11 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 46856

Part Number: D32075

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/04/16 (XII)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

LMO/MS

(XII)
09/04/17

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109648

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30
320°
9:00

BL 09-04-20

(XII)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

09-04-20 (XII)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

245

9/4/20

(XII)

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

209/04/20

Job Completion



U 01.04.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

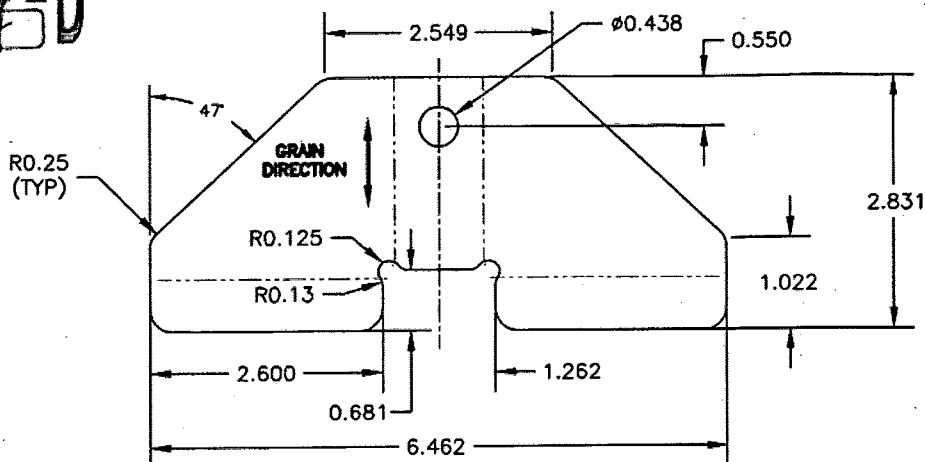
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

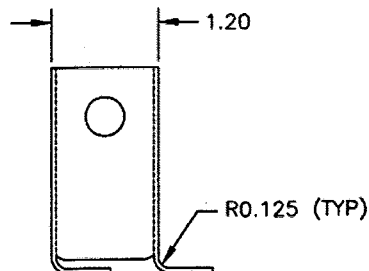
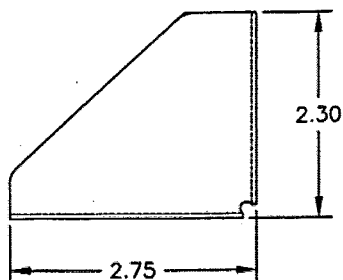
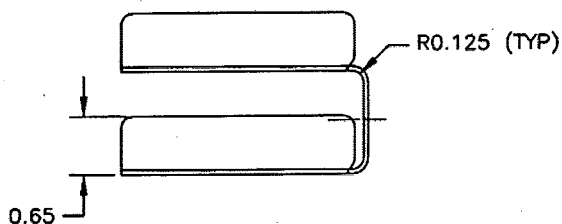


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3207	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE BRACKET		SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



D3207-1/-2 FLAT PATTERN



**D3207-1 BEND DETAIL (SHOWN)
D3207-2 OPPOSITE**

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 46850

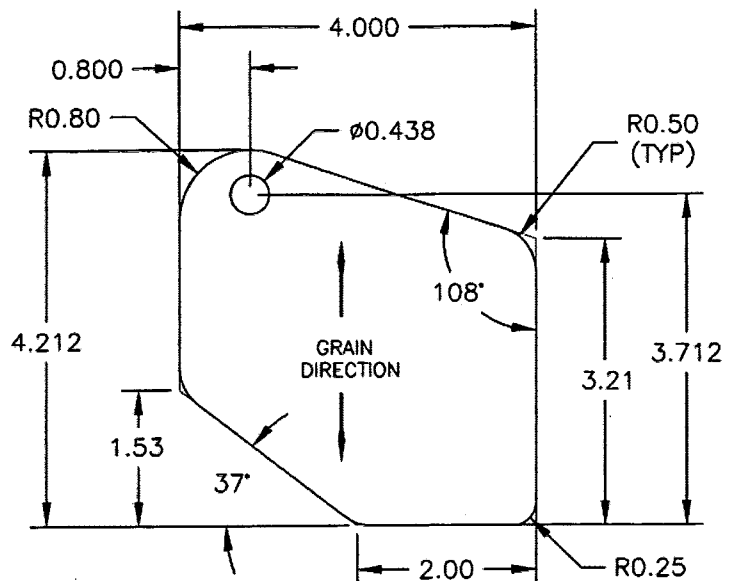
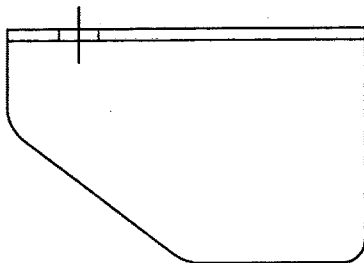
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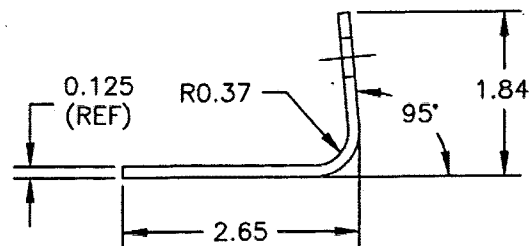
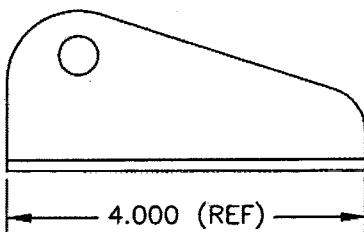
DART

DESIGN 7#	DRAWN BY 7#	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 7#	APPROVED 7#	DRAWING NO. D3207	REV. A SHEET 2 OF 3
DATE 04.01.27	TITLE BRACKET		SCALE 1:2

RELEASED
04.04.05



D3207-3 FLAT PATTERN



D3207-3 BEND DETAIL

D3207-3 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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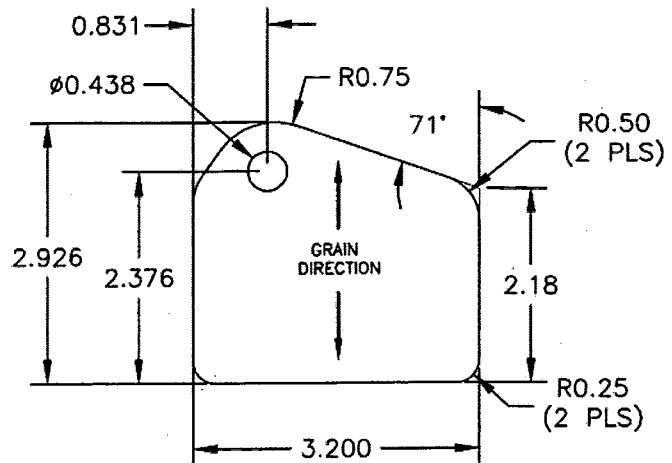
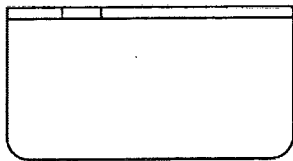
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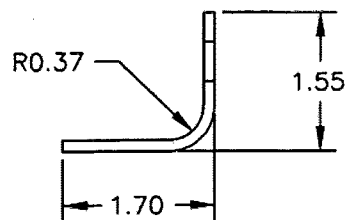
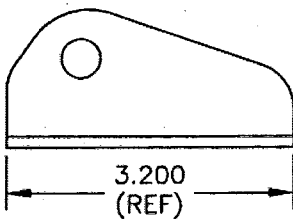
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CHECKED #	APPROVED #	DRAWING NO. D3207	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE BRACKET	SCALE 1:2

RELEASED
04.04.05 #

2157



D3207-5 FLAT PATTERN



D3207-5 BEND DETAIL

D3207-5 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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